

~~ASAP~~

Dart Aerospace Ltd.

Date: Saturday, 13/10/2007 11:31:31 AM  
User: Linda Lacelle

Process Sheet

Ship Monday  
15/10

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LEG  
Job Number : 35168  
Estimate Number : 12907  
P.O. Number : Part Number : D35233  
This Issue : 13/10/2007 S.O. No. : Drawing Number : D3523 REV B  
Prsht Rev. : NC Project Number : N/A  
First Issue : / / Type : MACHINED PARTS Drawing Revision : B  
Previous Run : 33295 Material :  
Written By : Due Date : 20/10/2007 Qty: 5 Um: Each  
Checked & Approved By :  
Comment : Est Rev:A New Issue 07-06.15 EC  
Est Rev:B Added Helicoil 07-07-19 JLM Verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6R1000 ROUND BAR 1.00"



Comment: Qty.: 0.1218 f(s)/Unit Total: 0.6090 f(s)  
6061-T6 round bar 1.00"  
(M6061T6 round bar 1.00")  
Batch: M164554

DJP 07/10/13

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA702 & dwg D3523

DJP 07/10/13 (6)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/10/13 (6)

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE  
Drill For Helicoil & Set-Screw

DJP 07/10/13 (6)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 07/10/14 (6)

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 35168

Part Number: D35233

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

⑥

J.L. 07/10/14

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

m 07 10 15

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

-Mask threaded holes & Ball as per Dwg D3523

-Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

N/A Dwg does not require P.Coat.  
07-10-15

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-10-15

10.0

MS21209F120

HELI COIL



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

HELI COIL

Batch: M104996

07/10/15 ⑥

11.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Install Helicoil as per Dwg D3523

07/10/15 ⑥

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/15 ⑥

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/10/16 ⑥

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEG

Job Number: 35168

Part Number: D35233

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.16 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*[Signature]* 07.10.16

8

7

6

5

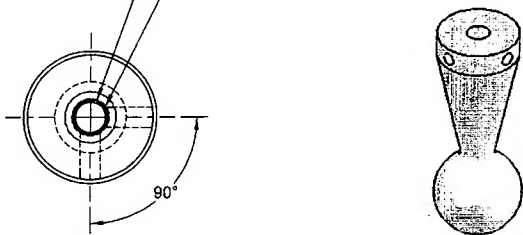
4

3

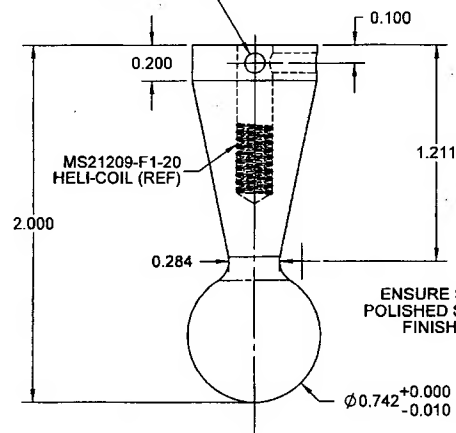
2

DRILL #7 ( $\phi 0.201$ ) x 0.83 DEEP  $\triangle B$   
TAP HOLE FOR #10-32 HELI-COIL INSERT (RED)

INSTALL MS21209-F1-20 HELI-COIL  
TO THE BOTTOM OF THE HOLE



DRILL #33 ( $\phi 0.113$ )  
TAP #6-40 UNF  
(2 PLACES)



ENSURE SMOOTH,  
POLISHED SURFACE  
FINISH ON BALL

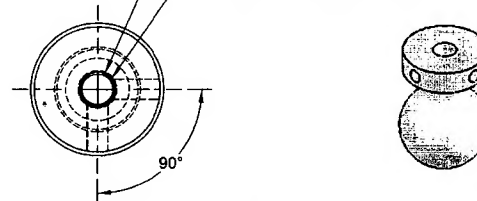
$\phi 0.742^{+0.000}_{-0.010}$

**D3523-1 LEG**

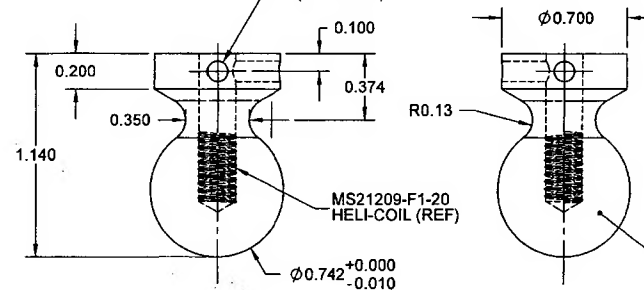
R0.13

DRILL #7 ( $\phi 0.201$ ) x 0.83 DEEP  $\triangle B$   
TAP HOLE FOR #10-32 HELI-COIL INSERT (RED)

INSTALL MS21209-F1-20 HELI-COIL  
TO THE BOTTOM OF THE HOLE



DRILL #33 ( $\phi 0.113$ )  
TAP #6-40 UNF  
(2 PLACES)



ENSURE SMOOTH,  
POLISHED SURFACE  
FINISH ON BALL

$\phi 0.742^{+0.000}_{-0.010}$

**D3523-3 LEG**

**RELEASED**  
07.08.03

$\triangle B$

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR AMS 4115/4116/4117/4128 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3523-1: 0.05 lbs  
D3523-3: 0.03 lbs

B	ZONE D7, D3: HOLE DEPTH REVISED FROM 0.69 TO 0.83 ZONE A8: UPDATE NOTES: ADD WEIGHT UPDATE DRAWING FORMAT	CB	07.07.25
A	NEW ISSUE	CB	07.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	CE	DRAWING NO.	REV. B
MFG. APPR.	BE	D3523	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.	HA	LEG	3:2
DATE	07.07.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

4/0  
35188

